50 Um:

Each

Wednesday, 2/20/2008 4:23:20 PM User: **Process Sheet** : SPACER BUSHING **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 37541 Estimate Number : 10826 Part Number : D23273 P.O. Number : 2/20/2008 . D2327 REV D S.O. No. : **Drawing Number** This Issue : NC - . : N/A Prsht Rev. Project Number First Issue : //// Type : MACHINED PARTS **Drawing Revision** : 36697 Previous Run Material : 3/10/2008 Qty: **Due Date** Written By Checked & Approved By Removed 303 SS Comment KJ/EC **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 M304R0375 304 SS ROUND BAR Comment: Qty.: Total: 8.2058 f(s) 0.1641 f(s)/Unit Inventory Material: AISI 304 Round Bar Ø0.375" (M304R0.375) HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr QC2 INSPECT PARTS AS THEY COME OFF MACHINE 3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

Comment: SECOND CHECK

PACKAGING 1 5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

PACKAGING RESOURCE #1

8/4/14

SECOND CHECK

	Dart	Aeros	pace	Ltd
--	------	--------------	------	-----

W/O:			WORK ORDER	CHANGES		* . *		
DATE	STEP	PF	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DO	QA:	Date: _	
				Q	A: N/C Clos	ed:	Date: _	

		WORK ORD	ER NON-CONFORMAN	CE (NCR)			
	Description of NC		Corrective Action Section B			A	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
					!		
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C	STEP Description of NC Section A Initial Chief Eng Chief

NOTE: Date & initial all entries

Date:

Wednesday, 2/20/2008 4:23:20 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 37541

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

1 25 1



08/04/144

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace l	Ltd							
W/O:			WC	RK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•									
			•						
Part No		PAR #:	Fault Cated	jory: NO	CR: Yes	No DQ	 A :	Date:	
								Date: _	
NCR:			NORK ORDE	R NON-CONFORMANC	E (NCR	R)			
		Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1	ion C	Chief Eng	QC Inspector
==									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37541
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	9,375	<u></u>			
Ø0.257	+0.005/-0.000	0,259"				
1.750	+/-0.010	9,375° 0,259° 1,750°				
			• • •			

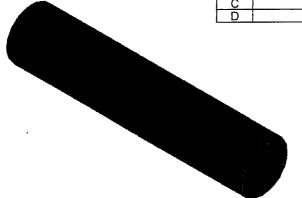
Measured by: Je F	Audited by: 20	Prototype Approval:	N/A
Date: 08/04/10	Date: 08 /04 /11	Date:	N/A

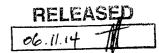
Rev	Date	Change	Revised by	Approved
Α	04.01.13	New Issue	KJ/RF	
В	06.11.24	Dwg Revision revised	KJ/JLM	
С	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	<i>X</i>

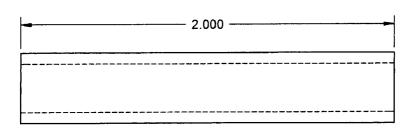


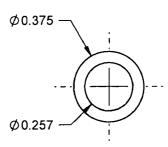
DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1	
DATE 06.1	10.12	TITLE SPACER BUSHING	SCALE 2:1	

1	00u.		
REV	DATE	DESCRIPTION	
Α	94.12.17	NEW ISSUE	
В	95.12.06	LENGTH CHANGE	
С	03.05.13	303 SS SPEC ADDED	
n	06 10 12	REMOVE 303 SS MATERIAL	









D2327-1 SPACER BUSHING

- 1.750 -

Ø0.375

Ø 0.257

UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

D2327-3 SPACER BUSHING

NOTES

1) MATERIAL: AISI 304/316 SS, ϕ 0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)

- 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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